

Date: Thursday, 01/05/2008 11:56:58 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 38944	
Estimate Number : 12974	
P.O. Number :	Part Number : D36463
This Issue : 01/05/2008 S.O. No. :	Drawing Number : D3646 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 37099	Material :
Written By :	Due Date : 06/05/2008 Qty: 20 Um: Each
Checked & Approved By : <u>MD 08.5.01</u>	
Comment : Est Rev. A new issue 07.07.25 EC verified by:JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 3.0555 f(s)/Unit Total : 30.5550 f(s)
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)

SB 08/05/02

Batch: M107403

(17)

M107166

(3)

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Punch to length as per Dwg D3646 & template DT8959

SB 08/05/02

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- Bend as per dwg D3646

FF 08/05/07 (20)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 08/05/07 (20)

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M106700

H 08-05-08

(Y20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 11:56:58 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 38944

Part Number: D36463

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: 1:50pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:20pm

8/1 08-05-08

(X201)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 08/05/08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



20X

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 226

8/1/8

SO

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

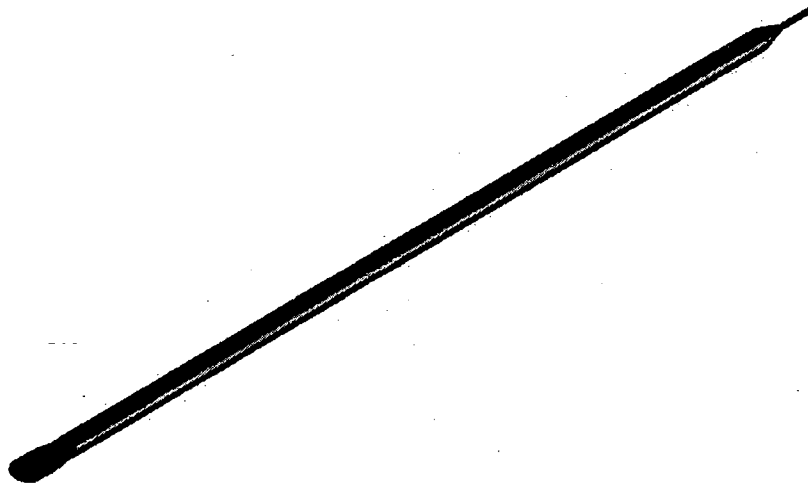
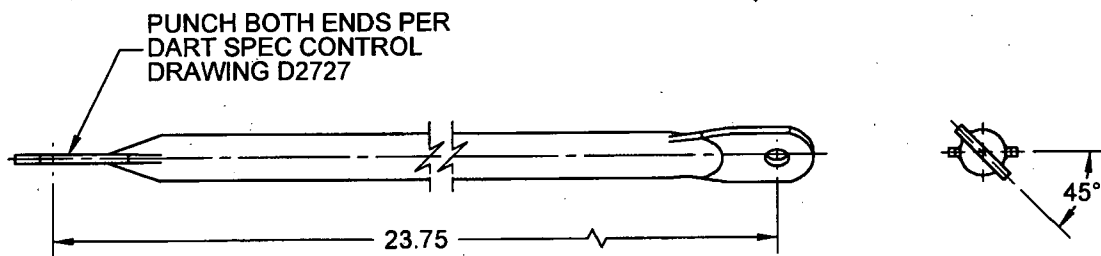
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3646	REV. A SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

RELEASED07.07.11 *PH***D3646-1 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

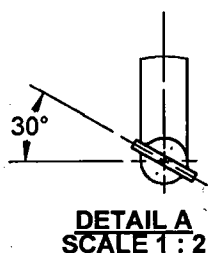
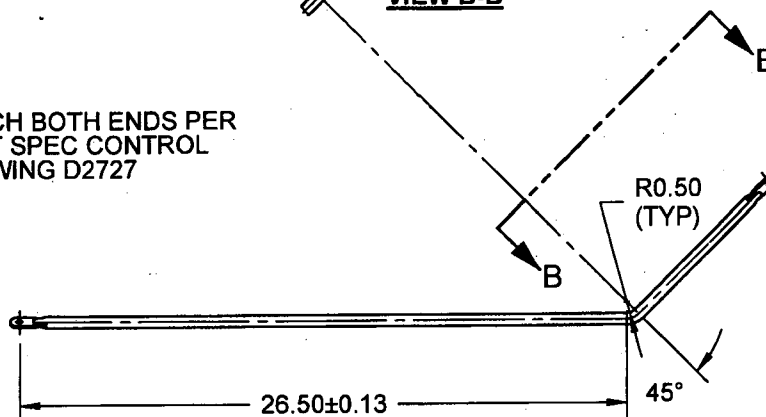
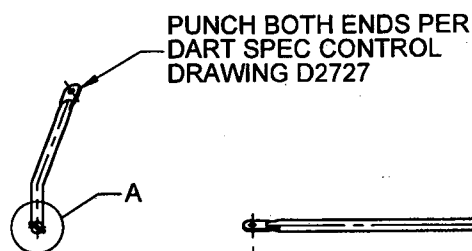
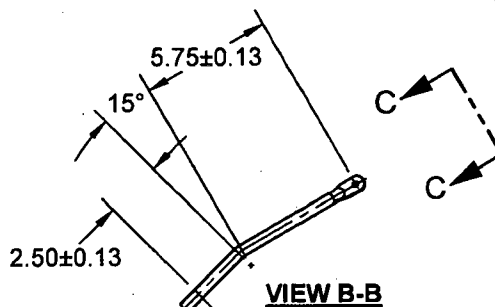
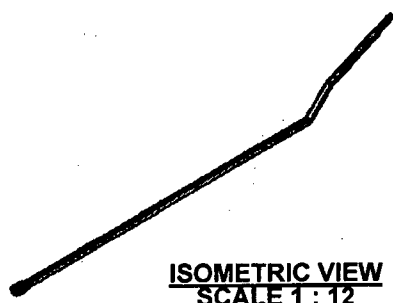
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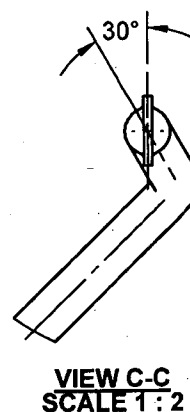
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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3646	REV. A SHEET 2 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:8



RELEASED
07.07.11



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NO. 38944

D3646-3 ARM

NOTES:

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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